

Work Order ID 71687

Thursday, July 07, 2011 12:54:16 PM



Page 1

Item ID:	D3259-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	7/7/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>4/07/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble D3259-041 as per Dwg D3259 .□Note:Keep .040" Gap all around door.								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 11/09/21 (4)

EP 11/09/21 (4)

(40)
WZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71687

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Item ID: D3259-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>132</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/21 411/9/22 [Signature]

MF 11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71687

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly









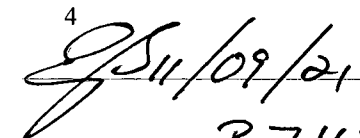



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD3-5  Rivet		Purchased	No			100	Each	3,892.000	10	40			
													
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST319 3892													
104817 3030													
9682 862													
D3161-5  Hinge 9.9"		Manufactured	No			110	Each	14.0000	1	4			
													
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST037 14													
47187 2													
47773 12													
D3259-1  Panel		Manufactured	No			110	Each	1.0000	1	4			
													
													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST180 1													
60082 1													
D3259-4  Doubler		Manufactured	No			110	Each	0.0000	1	4			
													
													

B72151 (3x)

B71680 (4x)

B71685 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 71687

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3259-5

Manufactured No

110 Each

3.0000

1

4



Spacer

Location

Loc Qty

Loc Code

ST180

3

60084

3

D3259-7

Manufactured No

110 Each

1.0000

1

4



Door

Location

Loc Qty

Loc Code

ST180

1

58751

1

D3260-1

Manufactured No

110 Each

0.0000

2

8



Spring

B72234(2x)

B71631(6x)

D3973-5

Manufactured No

110 Each

68.0000

2

8



Receptable, Rigid, DZUS

Location

Loc Qty

Loc Code

ST101

68

58759

68

D3974-20

Manufactured No

110 Each

91.0000

2

8



Stud, Wing Head, 5/16 DZUS

Location

Loc Qty

Loc Code

ST103

91

58761

66

61160

25

Handwritten notes and signatures:

- Signature: *[Signature]* 7/11/09/21
- 371629 (3x)
- 371682 (1x)
- Signature: *[Signature]* 7/11/09/21
- B71689 (4x)
- Signature: *[Signature]* 7/11/09/21
- Signature: *[Signature]* 7/11/09/21
- Signature: *[Signature]* 7/11/09/21
- 8
- Signature: *[Signature]* 7/11/09/21
- 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71687

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-4 Purchased No
Rivet

110 Each 2,452.000 4 16

Location

Loc Qty

Loc Code

ST317

2452

116188

2452

MS20470AD3-4 Purchased No
Rivet, Universal Head

110 Each 9,156.000 36 144

Location

Loc Qty

Loc Code

ST319

9156

111477

8332

15541

824

11.09.20

A3972-5

fy 2

B-60452

11.09.21

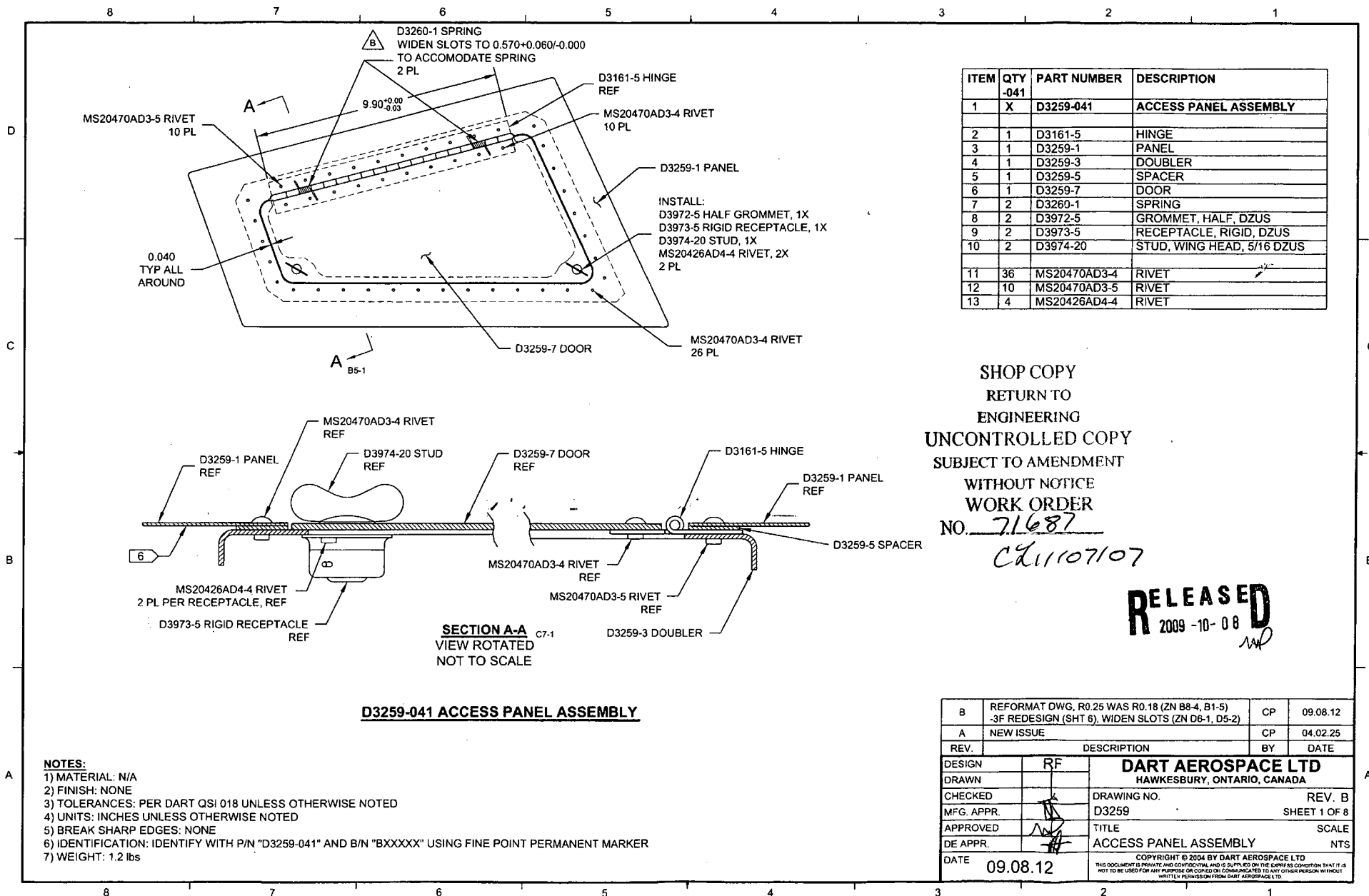
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

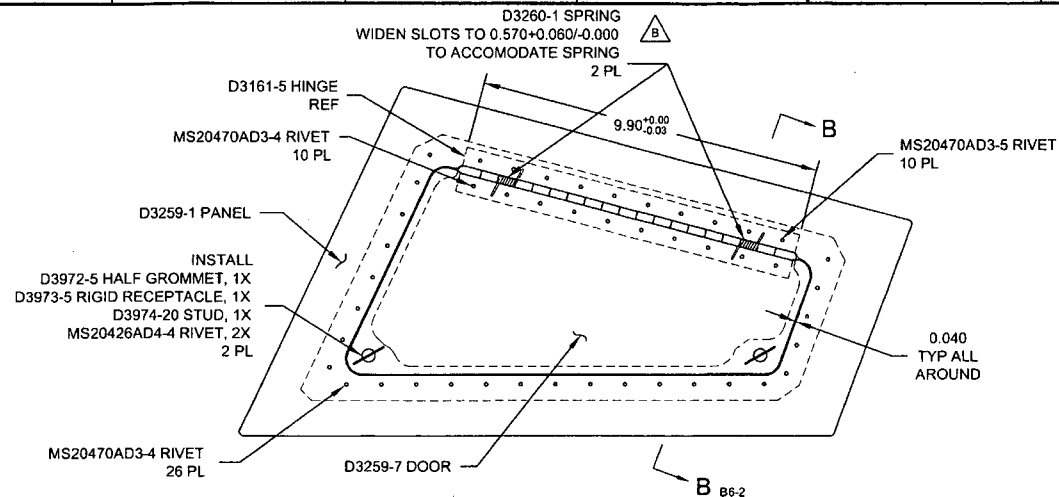
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

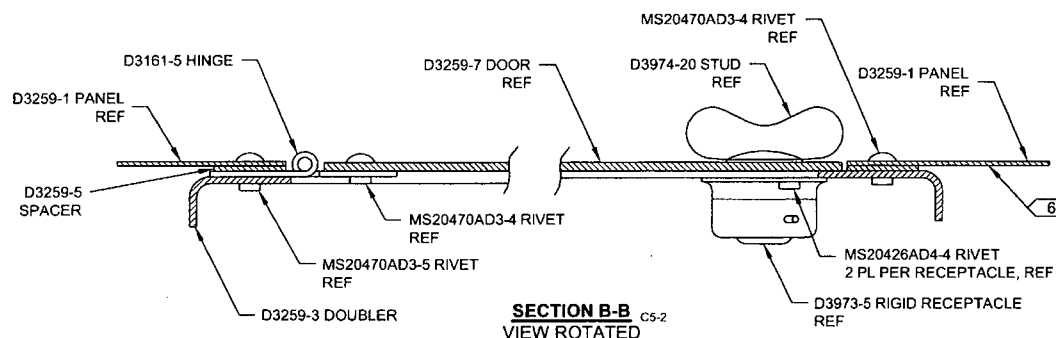
NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET






D3259-042 ACCESS PANEL ASSEMBLY

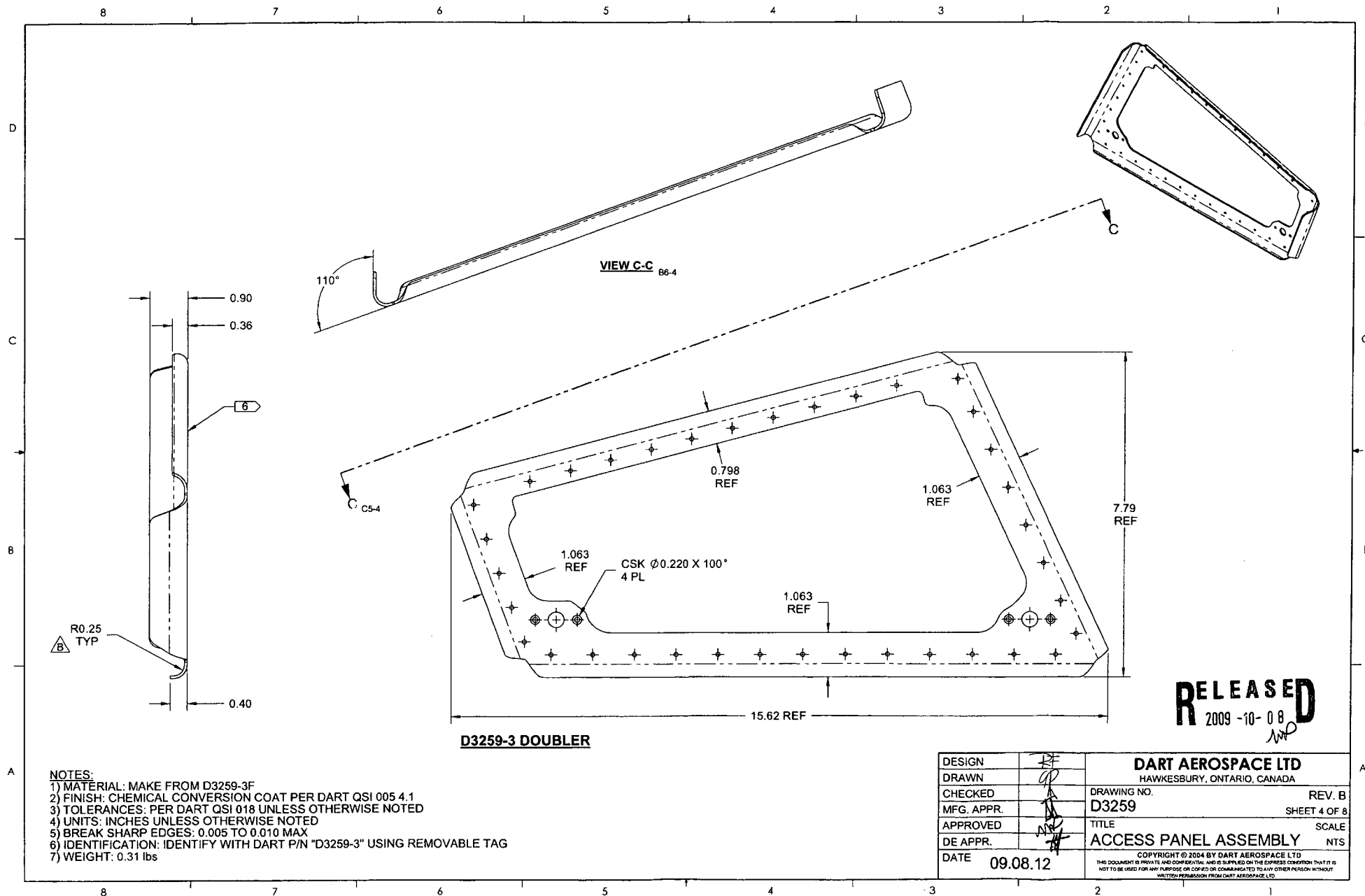
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

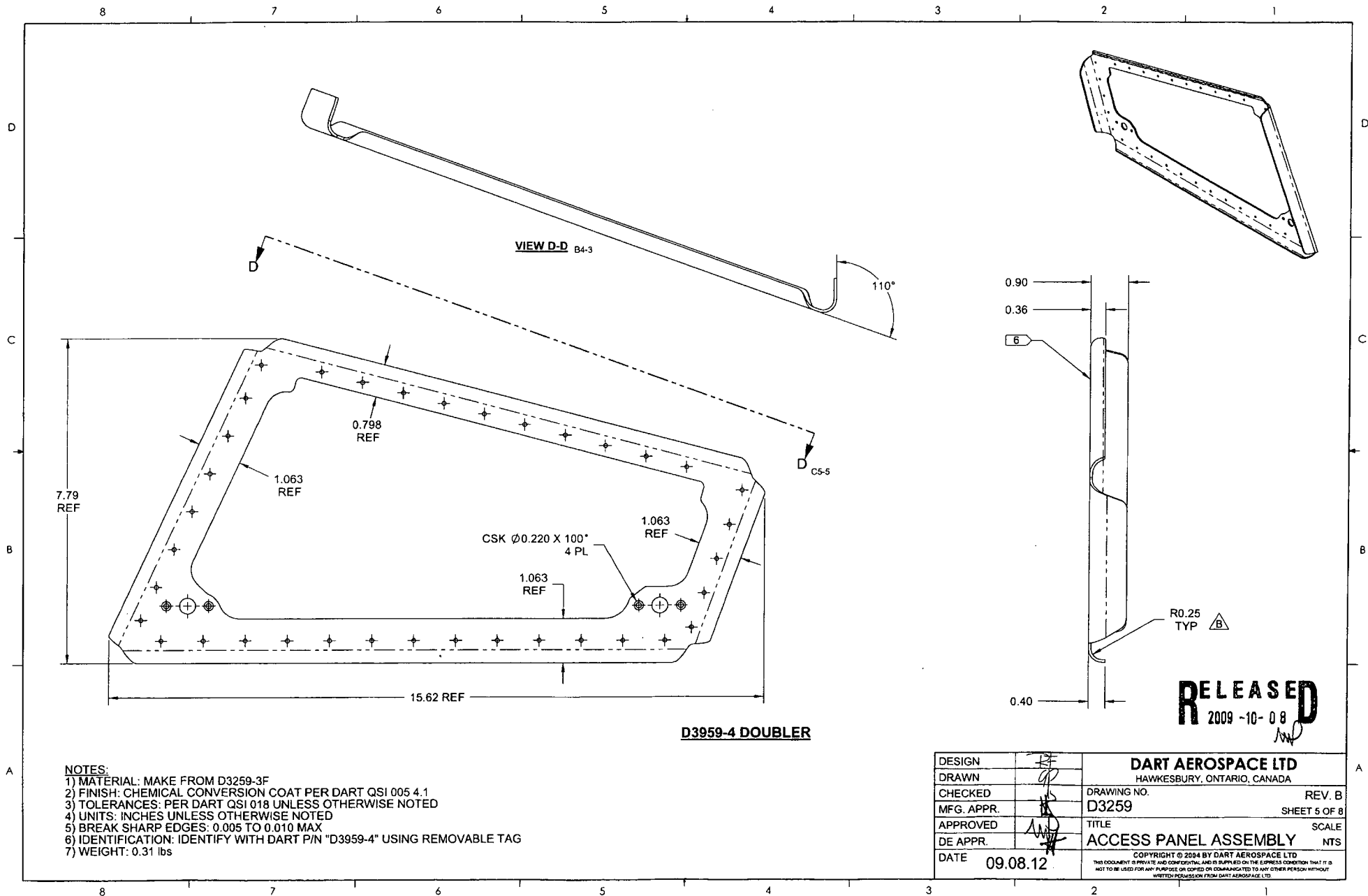
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CHECKED		D3259	SHEET 2 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	NTS
DE APPR.		DATE 09.08.12	
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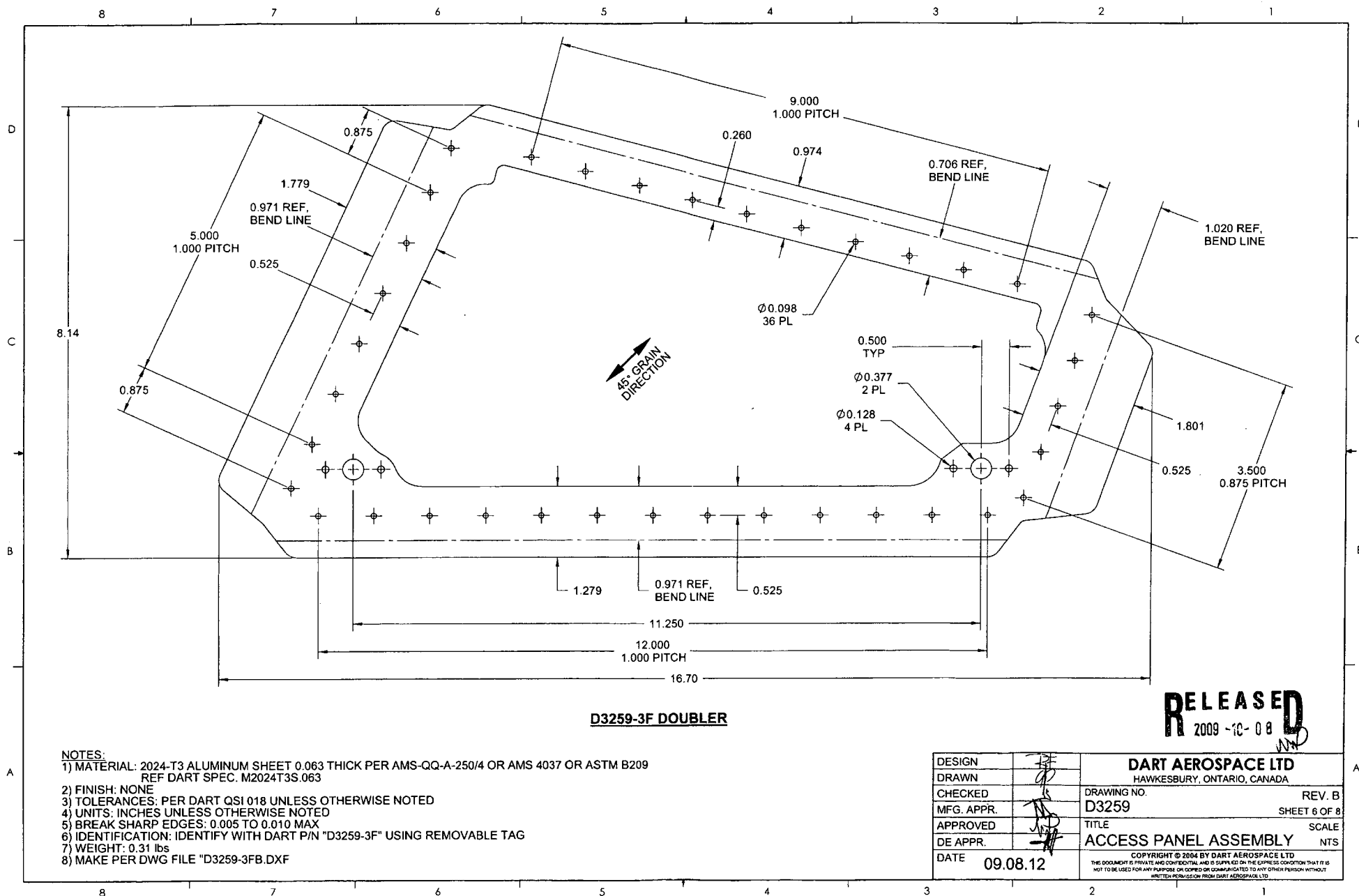
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2009-10-08
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DESIGN	DF	DART AEROSPACE LTD	
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APPROVED	WPD	TITLE	SCALE
DE APPR.	#	ACCESS PANEL ASSEMBLY	NTS
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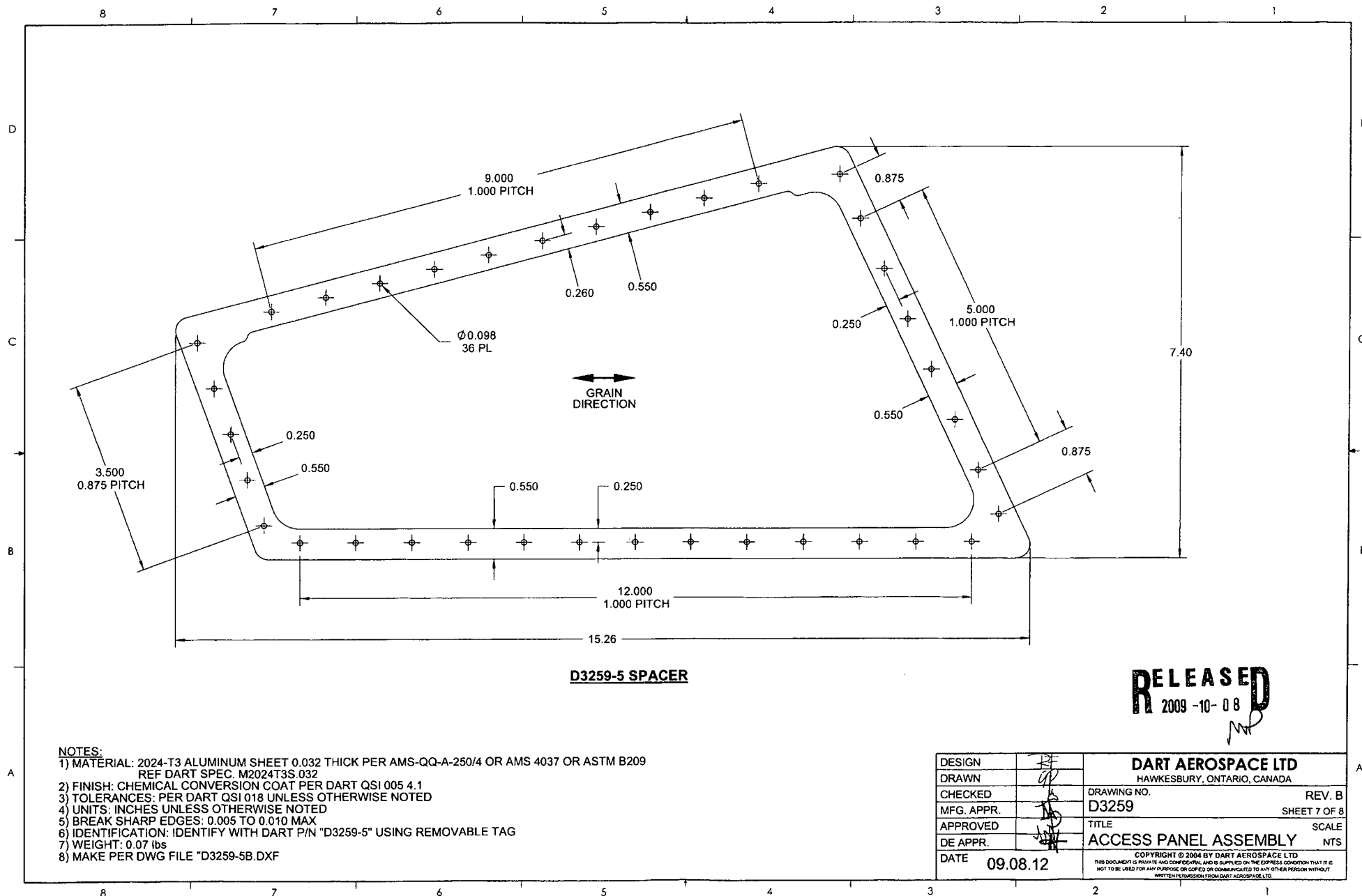
D3259-3F DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

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MFG. APPR.		D3259	SHEET 6 OF 8
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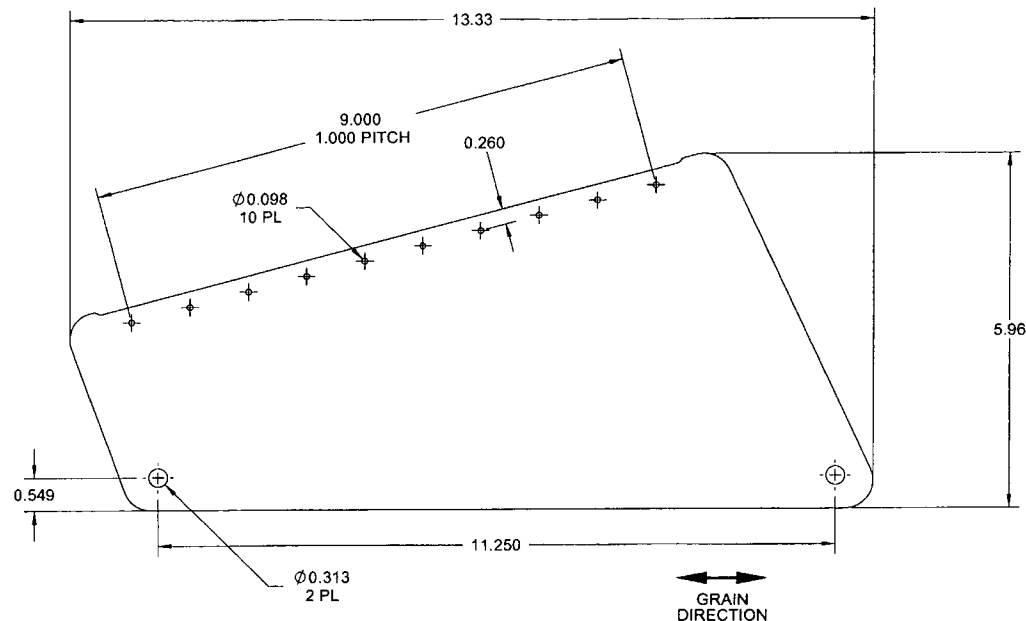
D3259-5 SPACER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

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D3259-7 DOOR

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2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 8 OF 8
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